

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008741**Date Inspected:** 03-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

<b>CWI Name:</b>	Pin-Tang Hsu		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	Tower, Jacking and Deviation Saddles	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date, 8/03/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

**WEST DEVIATION SADDLES**

W2W2 - Saddle is currently located at Blast facility to be cleaned and will then await Final PWHT NDE.

W2W3 - Saddle section in Fabrication Shop #4, is being welded by 2 welders on B shift. M.Kashiwada 08-2008 M.Kubota 74-3666 welding joints W3Y-13U, W3Y-14U respectively. The requirements established by SJ-3011-7 WPS were confirmed and verified periodically by QC CWI Mr. Chung Fu Kuan and later by Mr. Pin-Tang Hsu.

**TOWER SADDLES**

T1-3 - JSW employee Y.Ohta was in process tack welding stiffener plates 9ST-19, -20, -21 in place to complete fitup. Mr Ohta was using SMAW 4mm E7016 electrode per SJ-3012-8-1, and CWI Mr. Chung Fu Kuan reviewed his process to verify his parameters randomly.

**EAST SADDLES**

E2E1 - Cast section is having excess reinforcement on repairs ground, per JSW representative Mr. Hideaki Kon,

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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in the weld pit in Foundry, the NDE of the repair welding will then commence.

E2W1 - Idle. Now located in Fabrication Shop #4.

West Jacking Saddle - Foundry NDE technician N.Osawa #340 was in process of performing UT of as shaped/dressed surface of casting, currently scanning rib radii with 45° transducer, contoured, utilizing A scan type scopes. This cast section is located in the Foundry.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

### Summary of Conversations:

No significant conversations to report on this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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